



RELIABILITY INSPECTION REQUIREMENTS (RIR)

WORK DESCRIPTION: **43S86 Extruder Pellet Scalping Screen Top Plate cover Damage & Crack.**

MOC No/DSR Number :

PID No./ISOMETRIC No. : **NCP-43-P1-EF-814 / VP-2800-126-001-42V80-100**

SERVICE: **Pellet Fluff.**

DESIGN PRESS. (KG/CM²): **0 Kg/cm²**

DESIGN TEMP. (°C): **Ambient ° C (Open to atmospheric)**

WELD SPECIFICATION:

Welding procedure:	WPS NO.	PROCESS	Root	Fill & Cap	PWHT
	Other	See below			
Note:	Use WPS # CVX-2301 For Top Plate cover crack and Damage / Aluminium welding . To use the Aluminium filler wire ER-5356 .				

NDE REQUIREMENTS

VT : **100% for all completed welds & Edge Grinding Preparation**

PMI : **100% for Top cover plate (Before Cutting & welding)**

DPT : **100% for Edge grinding preparation & Final weld**

Non

<u>PRESSURE TEST</u>	Type of test	Test Press. (KG/CM²)	Test media	Duration	Pressure Type
	Min.gauge range	Max. gauge range	PRD Setting	Note:	
<u>Note:</u>					
<u>Test Results:</u>	Date :		Accepted		Rejected
	Name :			Comments:	

COATING REQUIREMENTS:

Painting Sys/Color : **N/A**

Surface Preparation :

Primer Coat :

DFT:

Intermediate Coat :

DFT:

Top Coat :

DFT:

Insulation: Yes ☐

No ☒

Type:

Note:

1.Before the cutting & welding Need to confirm with PMI inspection for Existing Top Cover Plate.

2. After PMI result proceed with attached RIR for Repair welding.

3.DPT inspection Need to done after the final weld.

4.Follow the attached WPS # CVX-2301 for repair welding welding.

Approvals:

Approved By : **Mohammed Al-Qarni**

DATE: **3/15/2021**

Inspector: **Rajeshkumar.M**

M. Rajesh Kumar